

# Work Order ID 52924

October 19, 2009 10:57:00 AM

Page 1

Item ID: D3957-041

Accept

Revision ID: A

Item Name: Hinge Assembly, Door LH Upper

Start Date: 10/19/09 Start Qty: 4.00

Required Date: 11/02/09 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 09-10-19 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3957

A

100

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

110

0.00

Small Fab

Memo

0.00

Small Fab

1-Install Helicoil in d3957-1

2-Install Rod end and Nut Loosely

0.00

120

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control



=> m-l 09/11/16 (6X)

=> m-l 09/11/16 (6X)

=> Sorulica (6X) p

# Work Order ID 52924



Page 2

October 19, 2009 10:57:00 AM

Item ID: D3957-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Hinge Assembly, Door LH Upper

Start Date: 10/19/09 Start Qty: 4.00



Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

9/11/10

6x SP

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/17

MF  
09-11-17

# Picklist Print

October 19, 2009 10:57:04 AM

Page 1

Work Order ID: 52924

Parent Item: D3957-041APRELIM

Parent Item Name: Hinge Assembly, Door LH Upper

Comments:

Start Date: 10/19/09

Required Date: 11/02/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3518-3RevB		Manufactured	No			100	Each	18.0000	4.0000			
Stainless Steel Ball Joint Rod End												

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

3

48211

3

Main Warehouse

ST109

15

51108

5

52270

10

MS124818

Purchased

No

100

Each

50.0000

4.0000

Helicoil

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

ST

50

112503

50

D3957-1A-PRELIM

Manufactured

No

100

Each

0.0000

4.0000

Hinge, Door LH Upper

B 53438

6X

M-L 09/11/16

M-L 09/11/16

2X  
4X

M-L 09/11/16

6X

# Picklist Print

October 19, 2009 10:57:04 AM

Page 2

Work Order ID: 52924

Parent Item: D3957-041APRELIM

Parent Item Name: Hinge Assembly, Door LH Upper



Start Date: 10/19/09

Required Date: 11/02/09

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS509-6 		Purchased	No			100	Each	18.0000	4.0000 			
Nut												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

109249

8

112492

10

2X  
4X

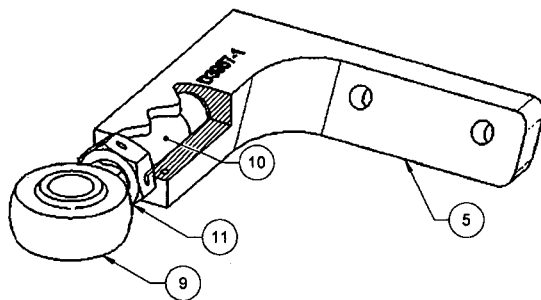
M-L 09/11/16

October 19, 2009 10:57:04 AM

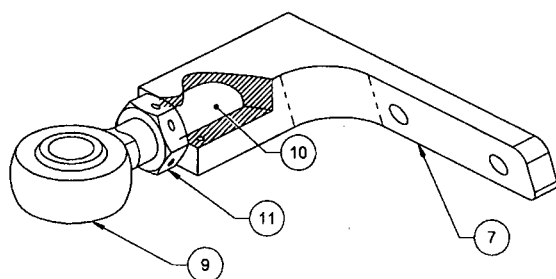
Shop Packet Print

Page 2

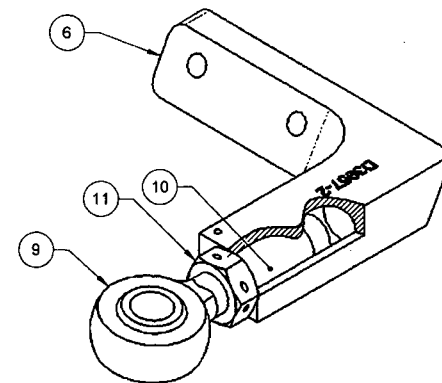
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1	X				D3957-041	HINGE ASSEMBLY, DOOR LH UPPER
2		X			D3957-042	HINGE ASSEMBLY, DOOR RH UPPER
3			X		D3957-043	HINGE ASSEMBLY, DOOR LH LOWER
4				X	D3957-044	HINGE ASSEMBLY, DOOR RH LOWER
5	1				D3957-1	HINGE, DOOR LH UPPER
6		1			D3957-2	HINGE, DOOR RH UPPER
7			1		D3957-3	HINGE, DOOR LH LOWER
8				1	D3957-4	HINGE, DOOR RH LOWER
9	1	1	1	1	D3518-3	ROD END
10	1	1	1	1	MS124818	HELICOIL, 3/8-24 UNF
11	1	1	1	1	NAS509-6	NUT



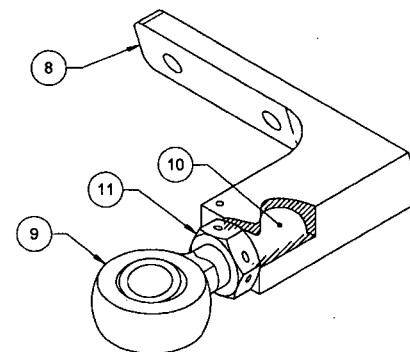
**D3957-041 HINGE ASSY, DOOR LH UPPER**



**D3957-043 HINGE ASSY, DOOR LH LOWER**



**D3957-042 HINGE ASSY, DOOR RH UPPER**



**D3957-044 HINGE ASSY, DOOR RH LOWER**

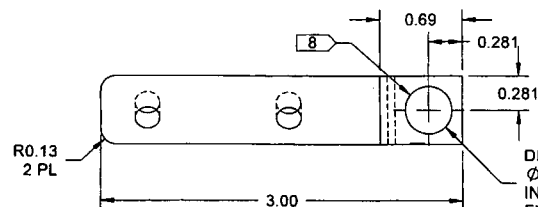
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO. 52927

PM 09-10-19

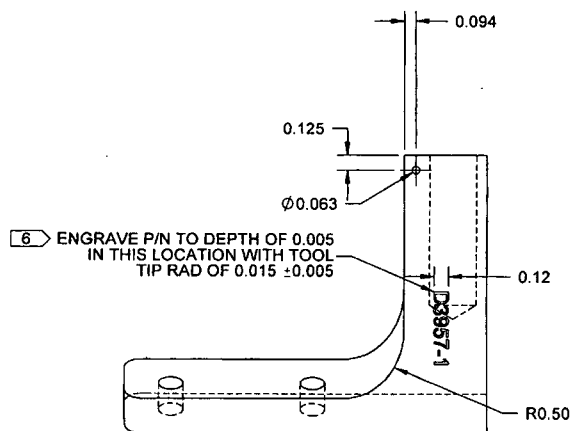
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2009-10-08  
JWP

A	NEW ISSUE	09.09.03
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.09.03	

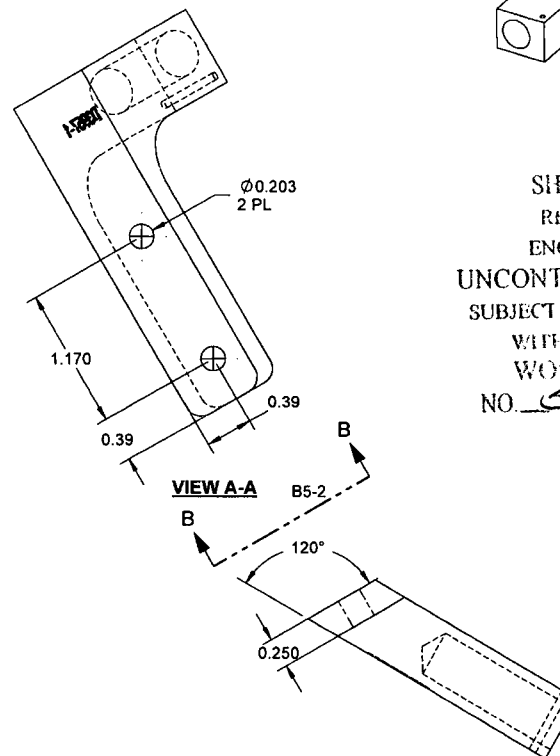
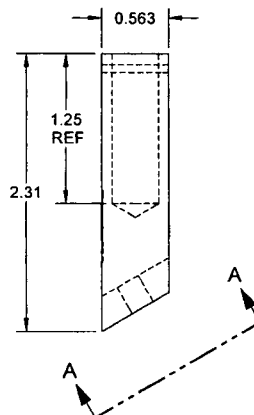
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3957</b>	REV. A
TITLE <b>HINGE</b>	SCALE NTS
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DRILL AND TAP FOR 3/8-24 HELICAL INSERT  
 $\varnothing 0.391 \times 1.25$  DP  
 INSTALL HELICOIL MS124818  
 FLUSH WITH SURFACE



6 ENGRAVE P/N TO DEPTH OF 0.005  
 IN THIS LOCATION WITH TOOL  
 TIP RAD OF 0.015  $\pm 0.005$



VIEW A-A

VIEW B-B

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 SUBJECT TO A  
 WITHOUT  
 WORK ORDER  
 NO. 52927

**D3957-1 HINGE, DOOR LH UPPER**

**NOTES:**

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR  
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.10 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

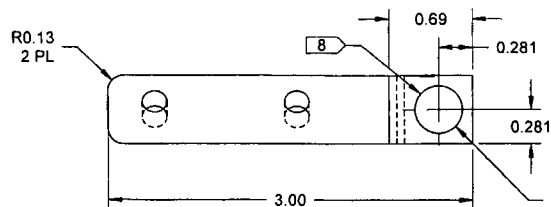
C3-2

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 2009-10-08

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DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	27	D3957	SHEET 2 OF 5
APPROVED	27	TITLE	SCALE
DE APPR.	27	HINGE	NTS
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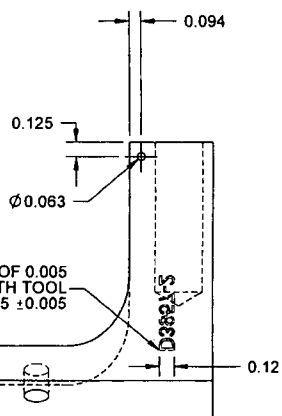
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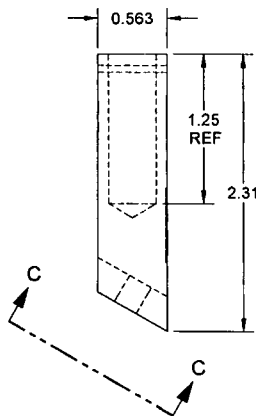


DRILL AND TAP FOR 3/8-24 HELICAL INSERT  
 $\varnothing 0.391 \times 1.25$  DP  
 INSTALL HELICOIL MS124818  
 FLUSH WITH SURFACE

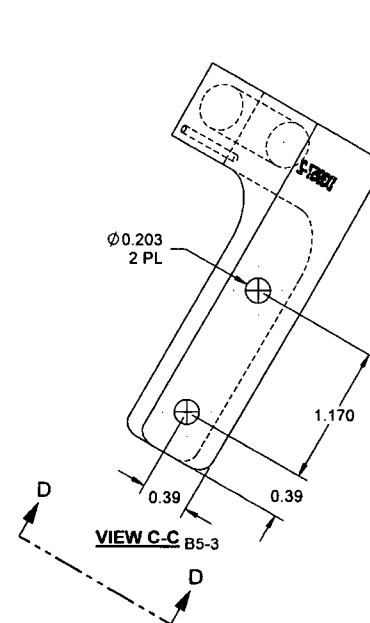
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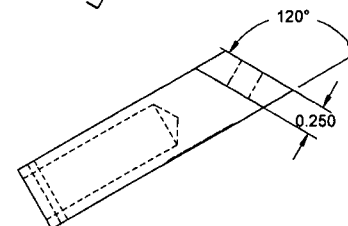
6 ENGRAVE P/N TO DEPTH OF 0.005  
 IN THIS LOCATION WITH TOOL  
 TIP RAD OF 0.015  $\pm 0.005$



**D3957-2 HINGE, DOOR RH UPPER**

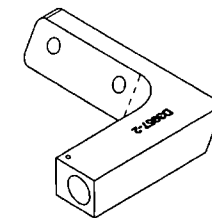


**VIEW C-C**



**VIEW D-D**

C3-3



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 WITH THE SAME  
 WORK ORDER NO.  
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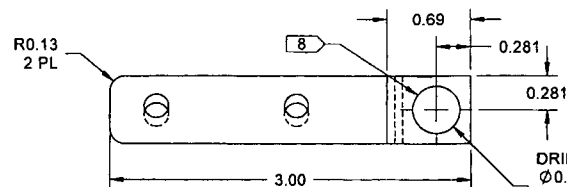
**NOTES:**

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR  
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 REF DART SPEC M6061T65
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.10 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

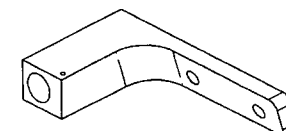
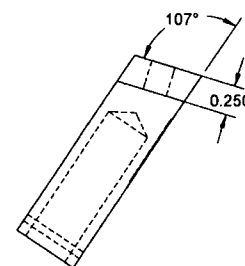
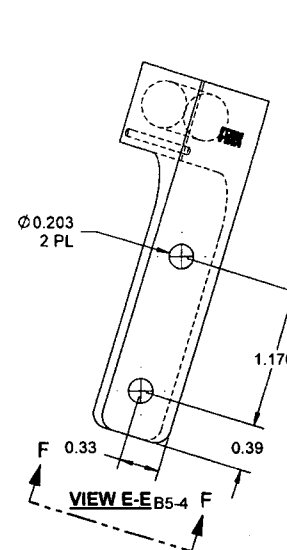
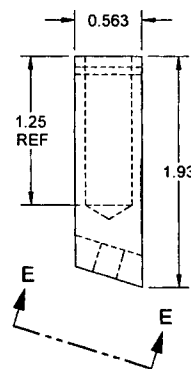
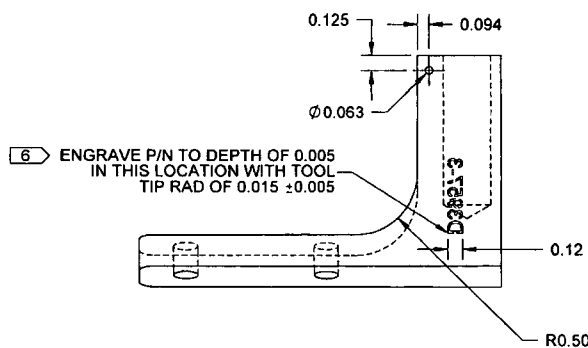
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MFG. APPR.	<i>PH</i>	D3957	SHEET 3 OF 5
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DE APPR.	<i>AS</i>	HINGE	NTS
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



DRILL AND TAP FOR 3/8-24 HELICAL INSERT  
 $\varnothing 0.391 \times 1.25$  DP  
 INSTALL HELICOIL MS124818  
 FLUSH WITH SURFACE



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 WORK NO. 52924

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**D3957-3 HINGE, DOOR LH LOWER**

**NOTES:**

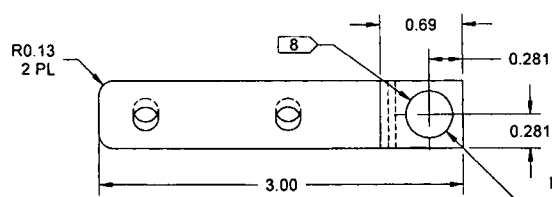
- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR  
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN	AS	<b>DART AEROSPACE LTD</b>	
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MFG. APPR.	2/1	D3957	SHEET 4 OF 5
APPROVED	1/1	TITLE	SCALE
DE APPR.	1/1	HINGE	NTS
DATE	09.09.03	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

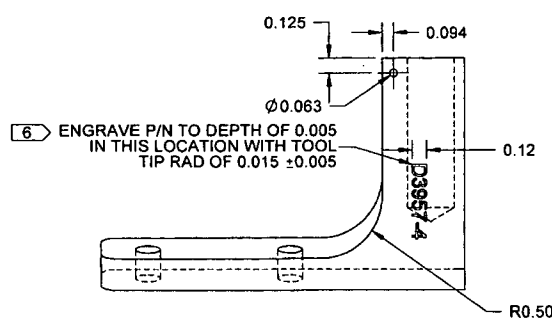
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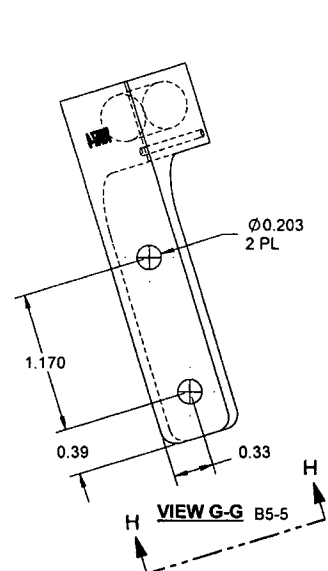
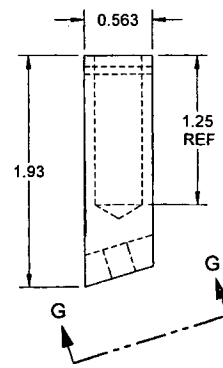
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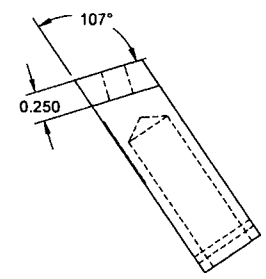
DRILL AND TAP FOR 3/8-24 HELICAL INSERT  
 $\varnothing 0.391$  X 1.25 DP  
 INSTALL HELICOIL MS124818  
 FLUSH WITH SURFACE



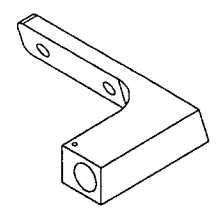
6 ENGRAVE P/N TO DEPTH OF 0.005  
 IN THIS LOCATION WITH TOOL  
 TIP RAD OF 0.015  $\pm$  0.005



VIEW G-G B5-5



VIEW H-H C3-5



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 SUBJECT TO APPROVAL  
 WITHIN 10 WORKING  
 NO. 52924

**D3957-4 HINGE, DOOR RH LOWER**

**RELEASED**  
 2009-10-08  
 AND

- NOTES:**
- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR  
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 REF DART SPEC M6061T6B
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
  - 7) WEIGHT: 0.09 lbs
  - 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN	<i>ES</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>ES</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PL</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>PL</i>	D3957	SHEET 5 OF 5
APPROVED	<i>AL</i>	TITLE	SCALE
DE APPR.	<i>AL</i>	HINGE	NTS
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